

75253

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

24

24

Customer:

Reference:

Run Start *NR1*

Tooling:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75253

October-19-11 1:36:08 PM

75253

Page 2

Item ID: D2857-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 19/10/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>11-11-03</i>			<i>[Signature]</i>			
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140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				<i>24</i>	<i>BR</i>	<i>11.11-3.</i>	
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160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>7:40</i> OVEN TEMPERATURE: <i>3200F</i> FINISH TIME: <i>8:10</i>	0.00 0.00				<i>24X</i>	<i>M-1</i>	<i>11/11/08</i>	
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M118439

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 75253

October-19-11 1:36:08 PM

75253

Page 3

Item ID: D2857-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 19/10/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>Q24</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

24x 6 11/11/08
COUNTED

P4418 (24)

11/11/08

WMS
11/11/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 75253

75253

Parent Item: D2857-1

D2857-1

Parent Item Name: Hinge Bracket

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C00.06.22Removed P/O for powder coatEC
 IPP D06.05.01Added level 8 EC IPP Rev:E
 10.06.10 remove seq150 DD verf:JLM IPP Rev:F 11.01.06 as
 per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	66.3026	0.37	9.347368			

M6061T6B2 000X01 250

6061-T6 Bar 2.00 x 1.25

Location	Loc Qty	Loc Code
MAT010	66.30263158	
114899	4.15263158	
116623	2.15	
→ 119136	60	

9.35 enr 11/10/31

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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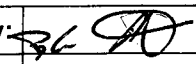

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	75253
Description: Hinge Bracket		Part Number:	D2857-1
Inspection Dwg: D2857 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.305			31006	
4.000	+/-0.010	4.001			"	
0.340	+/-0.010	.339			JLM 06	
1.110	+/-0.005	1.110			"	
1.790	+/-0.010	1.788			"	
1.320	+/-0.005	1.320			"	
2.000	+/-0.010	2.000			"	
0.340	+/-0.010	.340			"	
0.447	+/-0.010	.447			31006	
Ø0.171	+0.005/-0.000	.174			JLM 06	
0.147	+/-0.010	.147			"	
0.376	+/-0.010	.377			"	
0.126	+/-0.010	.126			"	
0.063	+/-0.010	.063			"	
					"	
Ø0.166	+0.005/-0.000	.169			"	
0.911	+/-0.010	.914			31006	
0.600	+/-0.010	.603			JLM 06	
					"	
0.125	+/-0.010	.125			"	
0.150	+/-0.010	.150			"	

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 11/11/02	Date: 11/11-03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM 	

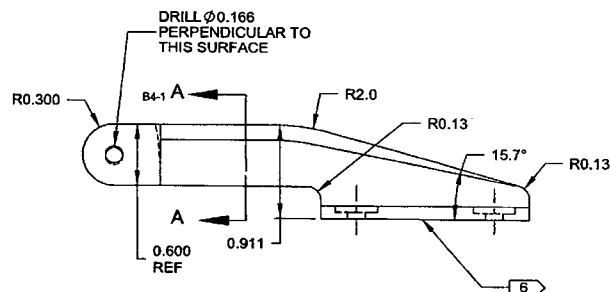
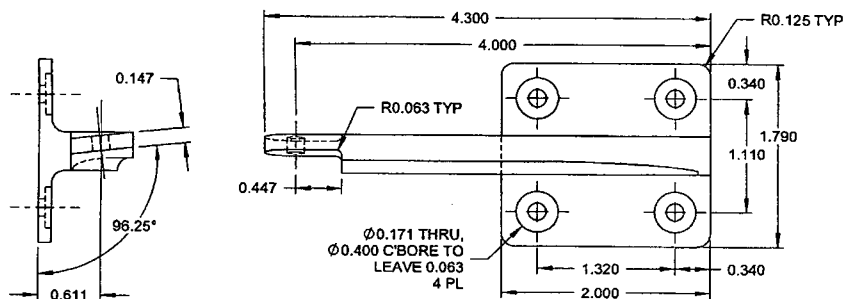
W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

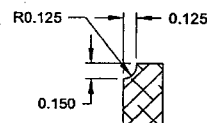
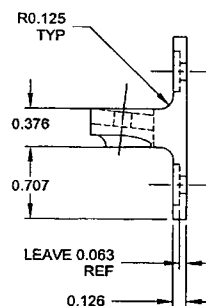
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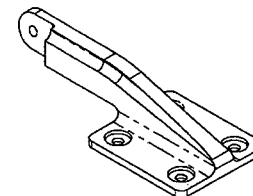
NOTE: Date & initial all entries



D2857-1 HINGE BRACKET



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75253 M.L.J

11/10/19

RELEASED
2010-11-26

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D2857-1" PER DART QSI 044 6.1(FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.11 lbs

C	REFORMAT DWG. IDENTIFICATION BY MARKER WAS ENGRAVING (A8-1), REF PAR 10-040	CP	10.09.13
B	ADD THICKNESS, REDRAW W/ SOLIDWORKS	LE	06.08.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KE		
CHECKED	KE	DRAWING NO.	REV. C
MFG. APPR.	KE	D2857	SHEET 1 OF 2
APPROVED	KE	TITLE	SCALE
DE APPR.	KE	HINGE BRACKET	NTS
DATE	10.09.13	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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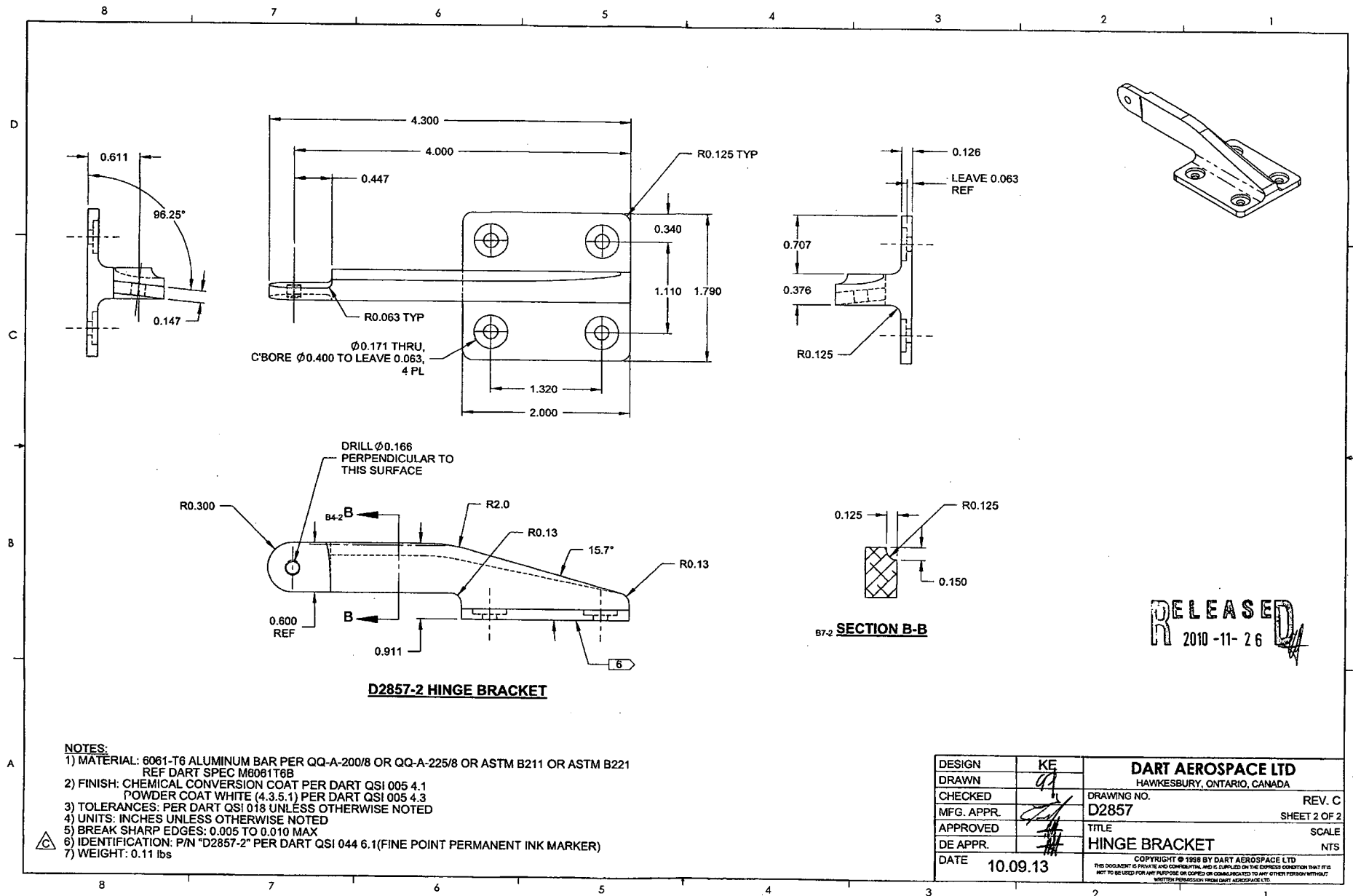
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